

Date: Tuesday, 06/01/2009 10:04:25 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CONSOLE SIDE PH (206 HI-SLOPE)
 Job Number : 44392
 Estimate Number : 11001
 P.O. Number :
 This Issue : 06/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : ~~D26022~~ D2601-2
 First Issue : / / Type : SMALL /MED FAB Drawing Number : D2602 REV B
 Previous Run : 43753 Project Number : N/A
 Material :
 Due Date : 31/01/2009 Qty: 4 Um: Each
 Written By :
 Checked & Approved By : JLD 09.01.06
 Comment : Est. E 04.02.25 Reformat KJ/RF
 Note: Issue with part number D2602-1
 Est Rev:E Now On Waterjet 07-03-22 JLM
 Est Rev:F RevB as per dwg ECN1059 DD vereified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S040 2024-T3 .040 sheet



Comment: Qty.: 1.4146 sf(s)/Unit Total : 5.6582 sf(s)
 2024-T3 .040 sheet
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick
 (M2024T3S.040) Batch 110337 1B 9-2-12

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D2602
 *****Same Cutting File for -1 & -2 *****
 Dwg Rev: B
 Prog Rev: B 1B 9-2-12
 2-Deburr if necessary 1B 9-2-12

(4)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

(P10)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

8 01/03/04 400

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2601-2 PAR #: N/A Fault Category: Prod/Eng Coordination NCR: Yes No DQA: D Date: 09/03/12
 Resolution: Process Revised Disposition: SR work QA: N/C Closed: D Date: 09/03/12

NCR: <u>44392</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/03/02	2.0	Incorrect parts made. D2602 as D2601. Employee worked off of the bag & the incorrect chug was attached. Affected w/o's: 45390, 44391 45391 & 44392	<u>[Signature]</u> 05/04/12	- See NCR 09-027 - Update this w/o to A D2601	<u>U</u> 09/03/02	<u>[Signature]</u> 09/03/02	<u>[Signature]</u> 05/04/12	<u>[Signature]</u> 09/03/02

NOTE: Date & initial all entries

Date: Tuesday, 06/01/2009 10:04:25 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE SIDE RH (206 HI-SLOPE)

Job Number: 44392

Part Number: ~~D26022~~ D2601.2

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Deburr if necessary

2-Form as per Dwg D2602

S/S 09/03/03

(4)

6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/03/06 44-2

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

mo/BK

09/03/09

(4)

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Q.M 09.03.06

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9/3/10

50

(4)

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/03/10

Job Completion



MF
09-03-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 44392
Description: CONSOLE GDE		Part Number: D2601-2
Inspection Dwg: D2601-2 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.101	X			
13.00	± .030	12.981	X			
1.35	± .030	1.352	X			
1.375	± .010	1.372	X			
.300	± .010	.301	X			
6.000	± .010	5.994	X			
9.45	± .030	9.45	X			
10.96	± .030	10.96	X			
8.875	± .010	8.878	X			
.340	± .010	.338	X			
.500	± .010	.500	X			
.875	± .010	.880	X			
1.254	± .010	1.247	X			
2.47	± .030	2.483	X			
.92	± .030	.911	X			
11.239	± .010	11.221	X			
10.76	± .030	10.694	X			
13.75	± .030	13.75	X			
14.18	± .030	14.18	X			
.838	± .010	.838	X			
2.648	± .010	2.650	X			
.040	± .010	.040	X			
			✓			

Measured by: B
Date: 9-3-3

Audited by: S
Date: 09/03/04

Prototype Approval: n
Date: 17

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

